

U.S. Ser. No. 09/143,503
U.S. Control No. 90/004,946

Exhibit 30

ADVANCED CARDIOVASCULAR SYSTEMS
EXTRUSION DATA SHEET

START TIME: EXTRUSION #: 10-581-1 AMOUNT (FEET): 2000
FINISH TIME: DATE: 5/9/94 SIGNATURE/DATE MM 5-9-94

MATERIALS :	MATERIAL DESC.	LOT# :	RM#
PEEK VICTREX		LPB 1335	NONE

EXTRUDER 10 PROCESS PERSON T.TOMAS

REQUESTOR J.LEE

PRODUCT ACX4 1315

SA#

SET-UP PARAMETERS:

MANDREL LGTH (EXT ONLY)	FLUSH	EXPERIMENTAL Y
DIE I.D. .094	OVAL N	PRODUCTION N
MANDREL O.D. .072	ROUND Y	STRAIGHT N
SCREW TYPE <u>PE 4770-3</u>	XHEAD Y	
SCREEN TYPE 20 80 20		
START ID/OD .032/.038		
FINISH ID/OD .032/.038		

PROCESS PARAMETERS

TEMPERATURE SETPOINTS

SPEEDS & SETPOINTS

PSI & AIR

ZONE 1 565.0 MELT	<u>810</u> °C	SCREW RPM	11.0	HEAD PSI	2129.0
ZONE 2 670.0 DIE	1	PSI SET	1391.0	DIE PSI	1762.0
ZONE 3 730.0 DIE	2	EXTR. AMP	10.1	AIR PSI 1	14.5
CLAMP 730.0 DIE	3	PUL SPEED	92		2 0.7
INLET 730.0 W/B TEMP		W/B DIST.	.70		3 0.2
G/PUMP 32.0					4 0.2
PMP OUT 670.0		Dried previously at 280°F 12 hrs			
XHEAD 0.0					
MATERIAL DRYING TMP. <u>320°F</u>		DEWPOINT <u>-54</u>	# OF HRS DRYING <u>13 hrs</u>		

ACTUAL PARAMETER COLLECTED EVERY 10 MINUTES

SETPOINT	ACTUAL 1	ACTUAL 2	ACTUAL 3	ACTUAL 4	ACTUAL 5
G/PUMP PSI	1375	1374	1378	1246	
PUMP AMP	0	0	0	0	
SCREW RPM	6	7	7	5	
EXTRUDER AMP	8	9	9	8	
PULLER SPEED					
BARREL 1	1694	1704	1555	1558	
BARREL 2	0	0	0	0	
BARREL 3	0	0	0	0	
HEAD PSI	1375	1374	1378	1246	
TUBING O.D.	0.0000	0.0000	0.0000	0.0000	
AVG.DIA.	0.0000	0.0000	0.0000	0.0000	
AVG.STD.DEV.	0.0000	0.0000	0.0000	0.0000	

Good run in
full auto